Dart Aerospace Ltd. Thursday, 5/31/2007 7:22:05 AM Kim Johnston **Process Sheet** : HELI-ACCESS STEP LH (FOLDING) : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 32715 **Estimate Number** : 12567 : D412630033 Part Number P.O. Number S.O. No. : NIA · IIN D412-630 REV K **Drawing Number** This Issue : N/A Project Number Prsht Rev. : LARGE FAB ASSY Type **Drawing Revision** First Issue Material Previous Run : 6/30/2007 Each Qty: Due Date Written By Checked & Approved By New Issue 06-11-08 Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: DOCUMENT CONTROL 1.0 Comment: DOCUMENT CONTROL 07.0605 Photocopy bluefile & create labels per PPP D412-630-033 CHG002 D2012107 Clevis 2.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Clevis Pick: Description Qty Part Number D2012-107 Clevis 3.0 D2803041 Bracket Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) **Bracket Assembly** Pick: Qty Part Number Description Bracket Assembly LH D2803-041 1

Bracket Assembly

6.0000 Each(s)

D2804041

Pick:

Qty

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Bracket Assembly

Part Number

D2804-041

1.0000 Each(s)/Unit

Total :

Bracket Assembly LH

Description

Comment: Qty.:

Batch 2756/ 1/2/1158

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Thursday, 5/31/2007 7:22:05 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 32715 Job Number: Description: Seq. #: Machine Or Operation: Support Prop D2807 5.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Support Prop Pick: Qty Part Number Description 2 D2807 Gas Spring Washer D2813 6.0 12.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Washer Pick: Description Qty Part Number 2 Washer D2813 7.0 D3562041 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Comment: Qty.: Step Weldment LH Pick: Part Number Description Qty Step Weldment LH 1 D3562-041 D33951 Bushing 8.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s) Bushing Pick: Qty Part Number Description D3395-1 Bushing 9.0 AN3C21A **BOLT** Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) **BOLT** Pick: Description Part Number Qty AN3C21A Bolt

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NOTE: Date & initial all entries

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Thursday, 5/31/2007 7:22:05 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 32715 Part Number: D412630033 Job Number: Description: Seq. #: Machine Or Operation: Bolt AN8C16 10.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Bolt Pick: Description Qty Part Number Bolt AN8C16 AN310C8 11.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Nut Pick: Description Batch Qty Part Number Nut AN310C8 MS24665302 12.0 Cotter Pin Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Cotter Pin Pick: Description Qty Part Number Cotter Pin (or AN380C3-4) MS24665-302 2 NAS1515H3 Washer 13.0 Comment: Qty.: 36.0000 Each(s) 6.0000 Each(s)/Unit Total: Washer Pick: Batch M 100 **99B** Description Qty Part Number NAS1515H3 Washer 14.0 NAS1515H5L WASHER Comment: Qty.: 24.0000 Each(s) 4.0000 Each(s)/Unit Total: **WASHER** Pick: Part Number Description Qty Washer NAS1515H5L

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Date: Thursday, 5/31/2007 7:22:05 AM User: 🕸 Kim Johnston **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 32715 Part Number: D412630033 Job Number: Description: Seq. #: Machine Or Operation: NAS1515H8 Washer 15.0 4.0000 Each(s)/Unit Total: 24.0000 Each(s) Comment: Qty.: Washer Pick: Batch Description Qty Part Number NAS1515H8 Washer 16.0 MS210433 Nut Comment: Qty.: 24.0000 Each(s) 4.0000 Each(s)/Unit Total: Nut Pick: Batch M104679 Description Part Number MS21043-3 Nut 17.0 MS24693C280 Screw Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Screw Pick: Qty Part Number Description Screw (or MS24694-C565) 2 MS24693-C280 SMALL & MEDIUM FAB RESOURCE 1 18.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: m/04929 COAT exposed HARDWARE WITH LPS PROCYON. BATCH: M A/R LPS PROCYON 19.0 QC5 Comment: INSPECT WORK TO CURRENT STEP

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Date: Thursday, 5/31/2007 7:22:05 AM User: Kim Johnston **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 32715 Job Number: Description: Seq. #: Machine Or Operation: PACKAGING RESOURCE #1 PACKAGING 1 20.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit D28061 Bushing 21.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Bushing 0407/2 Pick: Packing Kit Description Qty Part Number D2806-1 Bushing D28063 22.0 Comment: Qty.: 12.0000 Each(s) 2.0000 Each(s)/Unit Total: Bushing Pick: Packing Kit Part Number Description Qty D2806-3 Bushing D28105 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Packing Kit Qtv Part Number Description D2810-5 Strut D33961 Spacer Comment: Qtv.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Spacer Pick: Packing Kit Description Qty Part Number D3396-1 Spacer 2 AN4C6A Comment: Qty.: 1.0000 Each(s)/Unit Total: Bolt Pick: Packing Kit 7/7/23 / Qty Part Number Description Batch

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Thursday, 5/31/2007 7:22:05 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 32715 Job Number: Description: Seq. #: Machine Or Operation: AN4C6A Bolt Comment: Qty.: 6.0000 Each(s) 1.0000 Each(s)/Unit Total: Bolt Pick: Packing Kit Part Number Description Bolt AN4C10A AN4C15A Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Bolt Pick: Packing Kit Description Part Number AN4C15A Bolt AN44C7A Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Eyebolt Pick: Packing Kit Batch Qty Part Number Description Eyebolt AN44-C7A AN5C15A 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qtv.: Bolt Pick: Packing Kit Part Number Description 11/01/29/ AN5C15A Bolt NAS1515H4 Comment: Qty.: 7.0000 Each(s)/Unit Total: 42.0000 Each(s) Washer Pick: Packing Kit Part Number 1428 / 2/4/2359 Description NAS1515H4 Washer

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Date: Thursday, 5/31/2007 7:22:05 AM User: Kim Johnston **Process Sheet** Drawing Name: HELI-ACCESS STEP LH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630033 Job Number: 32715 Job Number: Description: Seq. #: Machine Or Operation: NAS1515H5 Washer 31.0 Comment: Qty.: 7.0000 Each(s)/Unit Total: 42.0000 Each(s) Washer Pick: Packing Kit Batch Part Number Description NAS1515H5 Washer MS210434 24.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Total: Nut Pick: Packing Kit Part Number Description MS21043-4 Nut MS210435 Nut Comment: Qtv.: Total: 18.0000 Each(s) 3.0000 Each(s)/Unit Nut Pick: Packing Kit Qty Part Number Description MS21043-5 Nut Comment: INSPECT 100% KITS FOR COMPLETENESS 35.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-033 Location: PPP Rev: 36.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE N Stof. 23 Job Completion

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Page 7

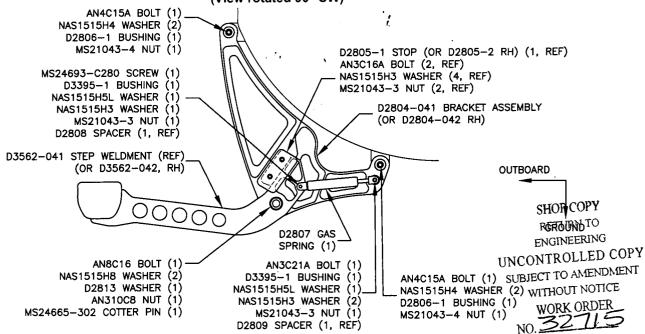
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D412-630-033/-034 Heli-Access-Step[™] Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-StepTM Installation (View rotated 90° CW) AN5C15A BOLT (1) NAS1515H5 WASHER (2) D2806-3 BUSHING (1) MS21043-5 NUT (1) MS24693-C280 SCREW (1) D3395-1 BUSHING (1) D2805-1 STOP (OR D2805-2 RH) (1, REF) NAS1515H5L WASHER (1) NAS1515H3 WASHER (1) MS21043-3 NUT (1) D2803-041 BRACKET ASSEMBLY D2808 SPACER (1, REF) (OR D2803-042 RH) AN8C16 BOLT (1) NAS1515H8 WASHER (2) D2813 WASHER (1) AN310C8 NUT (1) MS24665-302 COTTER PIN (1) OUTBOARD D2807 GAS SPRING (1) AN3C21A BOLT (1) GROUND D3395-1 BUSHING (1) NAS1515H5L WASHER (1) D3562-041 STEP WELDMENT (REF) AN5C15A BOLT (1) (OR D3562-042, RH) NAS1515H5 WASHER (2) NAS1515H3 WASHER (2) D2806-3 BUSHING (1) MS21043-3 NUT (1) MS21043-5 NUT (1) D2809 SPACER (1, REF)

FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step[™] Installation (View rotated 90° CW)



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Revision:

Date:

06.10.05

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